

Work Order ID 152082

Wednesday, October 19, 2016 3:28:36 PM

152082

Page 1

Item ID: PB67-43001-267

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pad Attachment Assembly

Start Date: 9/20/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

DAS
21
9-89

Date: OCT 20 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-267	Rev C								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001 Dwg Rev: C Prog Rev: C

****grain direction along 3.36" ****2-Deburr if necessary

PR 16/10/20

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

PR 16/10/20

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DAS
38
9-89

OCT 24 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						

Wednesday, October 19, 2016 3:28:36 PM

Page 2

NR2

[illegible]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 152082

Wednesday, October 19, 2016 3:28:36 PM

152082

Page 3

Item ID: PB67-43001-267 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pad Attachment Assembly
 Start Date: 9/20/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/19/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 <i>M 134092</i> Memo START TIME: <i>11:40</i> OVEN TEMPERATURE: <i>300°</i> FINISH TIME: <i>12:10</i>	0.00 0.00				<i>1 : φ : 16 :</i>			<i>DAS 34 9-89</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>1</i>			<i>DAS 38 9-89</i> <i>NOV 29 2016</i>
180 *180* Purchasing Purchasing	PURCHASING Memo SEND TO TALMAR FOR FOAM AND FABRIC <i>P/O: 34554</i>	0.00 0.00				<i>1</i>		<i>DEC 07 2016</i>	<i>DAS 13 9-89</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Work Order ID 152082

Wednesday, October 19, 2016 3:28:36 PM

152082

Page 4

Item ID: PB67-43001-267

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pad Attachment Assembly

Start Date: 9/20/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 Receive & Inspect for Damage & Mat'l Certs 0.00

190

Packaging

Memo

0.00

Packaging

K 2017-01-4

200 QC6- Inspect dimensions to drawing 0.00

200

QC

Memo

0.00

Quality Control

① 11.01.04 DAS 9 9-89

210 Identify as per dwg & Stock Location: W20001 0.00***210***

Packaging

Memo

0.00

Packaging

W20001
M 22 002

K. JAN 04 2017 DAS 26 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 152082

Wednesday, October 19, 2016 3:28:36 PM

152082

Page 5

Item ID: PB67-43001-267

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pad Attachment Assembly

Start Date: 9/20/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

DAS
21
9-89

JAN 09 2017

JAN 04 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Wednesday, October 19, 2016 3:28:36 PM

Work Order ID: 152082

152082

Parent Item: PB67-43001-267

PB67-43001-267

Parent Item Name: Pad Attachment Assembly

Start Date: 9/20/2016

Required Date: 10/19/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-20 new issue DD verified by:ec
10.10.04 per revC dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	106.0000	0.2566	0.270105			

M2024T3S 032

2024-T3 .032 sheet

PR 10/10/20

Location

Loc Qty

Loc Code

MAT022

106

M133452

13.2

M134581

2.8

M135010

25.6

M135032

64.4

0.279

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



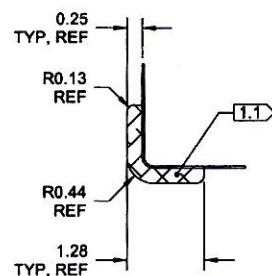
QA Closed: _____ Date: _____

Work Order update only ☐

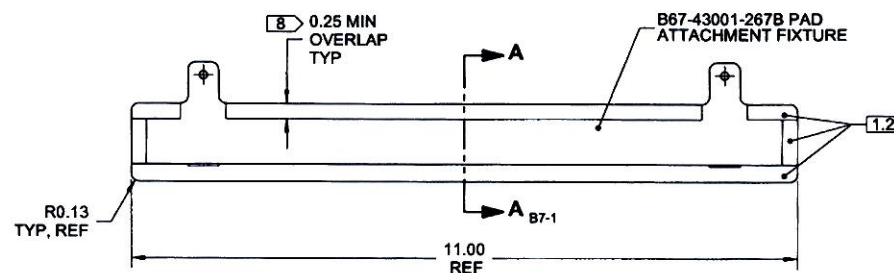
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

ITEM	QTY -267	P/N	DESCRIPTION
1	X	B67-43001-267	PAD ATTACHMENT ASSEMBLY
2	1	B67-43001-267B	PAD ATTACHMENT FIXTURE
3	A/R	1637-002	SEE NOTE 1.1
4	A/R	1495	SEE NOTE 1.2
5	A/R	LA4009	SEE NOTE 1.3

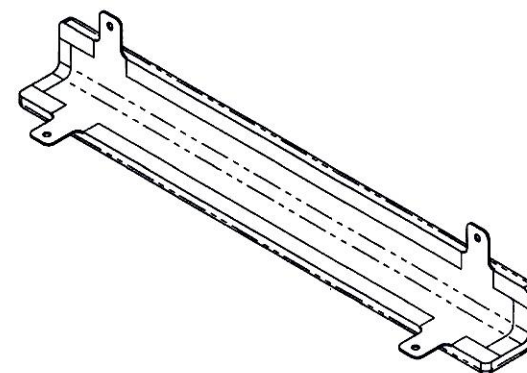
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152082 MLJ
16-10-20



SECTION A-A B5-1



B67-43001-267 PAD ASSEMBLY



NOTES:

1) MATERIAL:

1.1) FOAM: ETHYLENE PROPYLENE NEOPRENE SBR CLOSED-CELL, FLAME RETARDANT, 0.125 THICK, PER ASTM D1056 2A2, SERVICE TEMP -40°F TO +200°F, COLOUR: BLACK
REF. TULMAR P/N 1637-002

NOTE: FOAM MAY BE LAYERED AND BONDED TO 0.25 THICKNESS USING TULMAR P/N 1495 ADHESIVE
1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK
REF. TULMAR P/N 1495

1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009

2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.

3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: 0.17 lbs REF

8) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDES OF PLATE

TABLE 1 3

TOLERANCES ON FABRIC
(PARTS AND ASSEMBLIES)

±1/8: DIMS <2
±1/4: DIMS 2 TO <10
±1/2: DIMS 10 TO <20
±5/8: DIMS 20 TO <40
±1.5%: DIMS EQUAL TO OR > 40

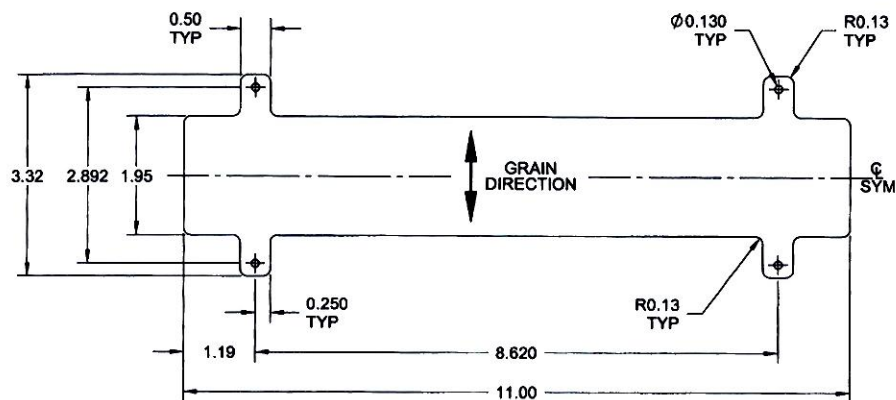
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC. FOR PREVIOUS REVISIONS, REFER TO SHEETS 14 AND 34 OF PREMIER AVIATION DRAWING NO. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-267 TITLE PAD ASSEMBLY COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		
DRAWN				
CHECKED			REV.	
MFG. APPR.			B67-43001-267	SHEET 1 OF 2
APPROVED				SCALE
DE APPR.	N/A			NTS
DATE	10.04.27			

RELEASED
R 2010-09-
MB

8 7 6 5 4 3 2 1

D

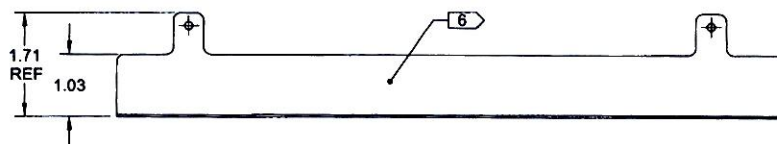
D



B67-43001-267F FLAT PATTERN (1)

C

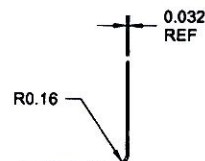
C



B67-43001-267B BENDING DETAIL (2)
(MAKE FROM B67-43001-267F)

B

B



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-267B" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

A

A

RELEASE
2010-09-16

DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		B67-43001-267	SHEET 2 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		PAD ASSEMBLY	NTS
DE APPR.	N/A	DATE 10.04.27 COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34554**

Purchase Order Date 12/7/2016

PO Print Date 12/7/2016

Page Number 1 of 2

Order From :

VC-TUL001

Ship To : DART AEROSPACE LTD

TULMAR SAFETY SYSTEMS
1123 CAMERON ST
HAWKESBURY, ON K6A 2B8
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone

613 632 1282

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Ship To Phone

Terms

Net 30

Ship Via:

VENDOR'S TRUCK

Currency

CAD

Ship Acct:

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	152117	PB67-43001-85 D-PAD ASSEMBLY	1/6/2017 Yes 1/6/2017		8.00	\$55.00	\$440.00

FOAM AND FABRIC
TULMAR P/N: 8421-102
INCLUDED MARK UPS AT REV.D + MU REV. D + 1
MISSING ON DART DWG. "TRANSFER DIAM 0.19 HOLE FROM WELDMENT TO FABRIC 2PL"

Line Total: \$440.00

2	152082	PB67-43001-267 PAD ATTACHEMENT	1/6/2017 Yes 1/6/2017		1.00	\$110.00	\$110.00
---	--------	-----------------------------------	-----------------------------	--	------	----------	----------

FOAM AND FABRIC AS PER DWG PB67-43001-267 REV. C + 1
TULMAR P/N: 8421-108

SP17-01-4

Line Total: \$110.00

Note:

12/7/2016

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8
Tel: 613-632-1282
Fax: 613-632-2030
GST R132478223
MID : XOTULSAF1123HAW
email: info@tulmar.com

Packing Slip No Page

59199 1

Ship Date

12/23/2016

Bill To:

Dart Aerospace

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

Canada

Ship To:

Dart Aerospace

1270 Aberdeen Street

Tel: 613-632-9577

Hawkesbury, ON K6A 1K7

Canada

Order number	Sales order date	Account number	Loc	Account manager
34382	12/7/2016	CDART100	H	Francine Bigras
PO number	Ship via	Shipping Terms		
PO34554	Pick-Up	FOB HAWKESBURY		

Item No. Description	Quantity ordered	UOM	Qty Shipped/Returned	Quantity on back order
-------------------------	------------------	-----	----------------------	------------------------

Line 3

Procurement Quality Clauses:

A004 A005 A007 A016 A026 A040

A041 A043 (TSS=5 yrs only)

8421-102	8.00	EA	8.00
----------	------	----	------

D-Pad Assembly, Long

Drawing No: B67-43001-85 + MU

DWG Rev: D+1

Line 1

SF 41067

Lot no.: BATCH0000000012 8.00

SET-UP OMO	1.00	EA	1.00
------------	------	----	------

Set-Up Fee

Line 4

8421-108	1.00	EA	1.00
----------	------	----	------

Dart Blade Fold Kit - Pad #9

Drawing No: B67-43001-267+MU

DWG Rev: C+1

Line 2

SF 41068

Lot no.: BATCH0000000009 1.00

DAS
9
9-89

SP H-01-4

Certificate of Conformance

☒ See Certification Enclosed

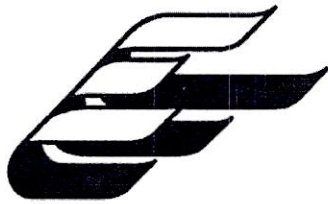
I hereby certify that the items listed hereon have been inspected, and / or tested (as applicable), conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector

Lorraine LaLiberté

Date:

DEC 23 2016



J. ENNIS FABRICS

June 10, 2015

Fax To: Tulmar Safety Systems
Fax: 613-632-2030
Attention: Sandra Nadeau

Certificate of Conformance

Re: PO 28594-00 for Oxford 7 black

The goods shipped on P/O 28594-00 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford 7 black is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating {approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.)}

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish; Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Piece # 111926200 Manufacture Date: 03/25/15, **Lot Number:** 444815

Sincerely;
J. Ennis Fabrics Ltd.

S, Nolan

Susan Nolan
Customer Service Specialist

JUN 19 2015



1495 # 33
B

cl's used to mfg. B-67-43001-267+mu
Rev. c+1

Louise Deliberte
Don 22/14

TULMAR**Certificate of Conformance**

Tulmar P/N 1637-002	Description 1/8" X 42" X 72"	Dwg #	Revision	Qty 2
Tulmar PO # 30234-00	Line Item # 01	Supplier Name / Address AM RUBBER & FOAM GASKETS INC. 2074 STEELES AVE. EAST, UNITS 1 & 2 BRAMPTON, ON. L6T 4Z9		Supplier Packing Slip # 16563

Supplier Declarations:

Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : CANADA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

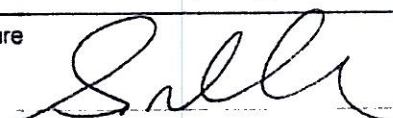
if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com

Additional Information (MRS#, MRA#, limitations, etc...):

FOAM, SBR/EPDM/CR BLEND, BLACK
ASTM D1056 2A2, 1/8" THK.
SHEET SIZE 42" X 72" +/-0.5"
BRITTLNESS TEMP OF -40 DEGREES F
IAW ASTM D746
QUALITY CLAUSE: GrBT3

DAS
9
9-89

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature 	Name SANDRA PULSINELLI	Date (DD-MMM-YYYY) 20-06-2016
Title PRODUCTION	Email sandra@amrubber.ca	Phone # 905-455-1449

1637-002 JUL 05 2016

B# 8 Ae



Form Revision 13 Aug 2012



48 Burgess Place
Wayne, NJ 07470

Certificate Of Analysis

12/12/2016

Sales Order Number: 8915
Customer Order Number: 30687

Manufactured for
TULMAR SAFETY SYSTEMS

14172-C6.9A LA4009NOVOC, P/N 7122-001 14172-C6.9A - LA4009NOVOC, UNLINED GALLON CAN

Lot# PNJ-1116-0171 Qty: 54 CANS + PART CAN @ 3# Manufacture Date: 11/15/16 Expiration Date: 11/15/17

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	14.4000	13.00	15.00	Percent
Brookfield,RVT,#3 Spindle,20RPM,78F	915.0000	800.00	1,500.00	Centipoise
Visual check for dry film color	pass	(CLEAR TO HAZY YELLOW) PASS/FAIL		

14556-S1.9 CAT7020, P/N 7153-002 14556-S1.9 - CAT7020 QUART CANS SQUARE UNLINED

Lot# PNJ-1116-0170 Qty: 11 EA Manufacture Date: 11/16/16 Expiration Date: 5/18/17

Test(s)	Results	Min	Max
	NOT APPLICABLE	NA	NA

14914-C7 DB7020M1, P/N 7153-001 14914-C7 - DB7020M1, GALLON LINED CAN

Lot# PNJ-1116-0172 Qty: 56 CANS + PART CAN @ 4# Manufacture Date: 11/21/16 Expiration Date: 5/23/17

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	23.0000	21.00	24.00	Percent
Brookfield,RVT,#3 Spindle,20RPM,78F	695.0000	450.00	1,250.00	Centipoise

"The material supplied conforms to all applicable engineering drawing, specifications and PO requirements."

Dan Constantino

Daniel Constantino
Quality Assurance Mgr/ISO Coordinator

Country of Origin: USA

7122-001
B#8

DEC 19 2016

